

Work Order ID 101186

May-02-13 3:27:18 PM

101186

Pa

Item ID: D4672-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blanking Plate

Start Date: 5/02/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/09/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *13-05-02* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4672

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4672

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr as required

20

DAS
05
13-05-06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20

DAS
05
13-05-06

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>W2004</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/5/8

Picklist Print

May-02-13 3:27:22 PM

Work Order ID: 101186

101186

Parent Item: D4672-1

D4672-1

Parent Item Name: Blanking Plate

Start Date: 5/02/13

Required Date: 5/09/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC IPP
REV:B 12.07.24 AS PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	327.9000	0.28	5.894737			

M304S20GA

304/316 .040 Sheet

**

13.05.06

Location

Loc Qty

Loc Code

MAT020

327.9

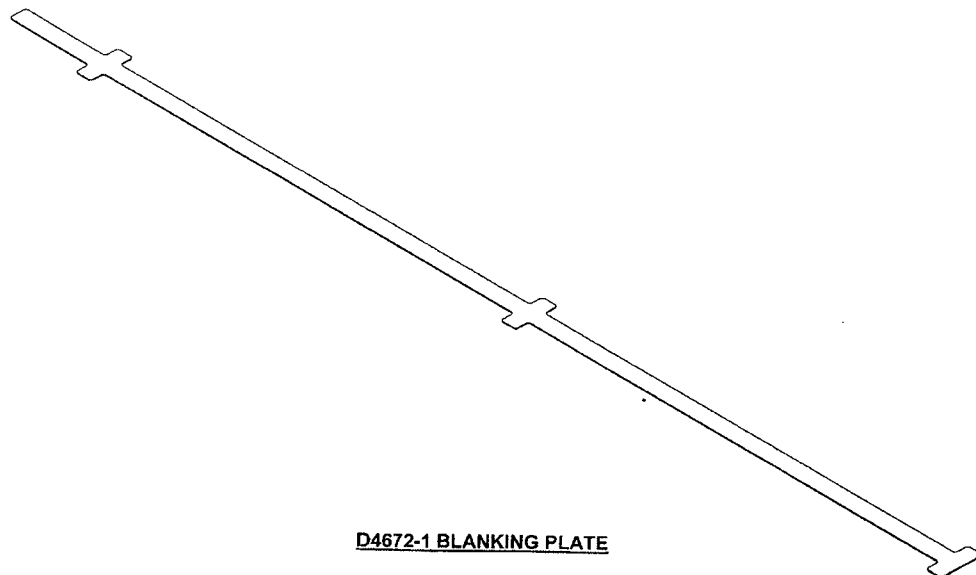
124029

117.15

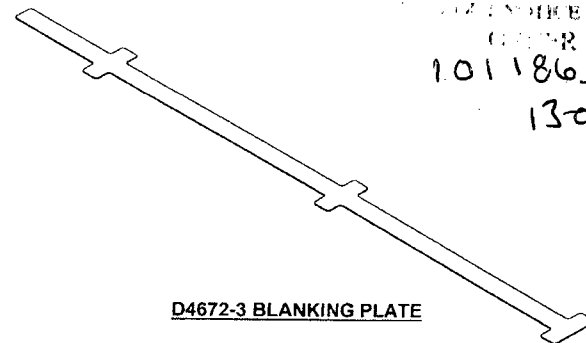
124956

210.75

101186_ML3
 130502



D4672-1 BLANKING PLATE



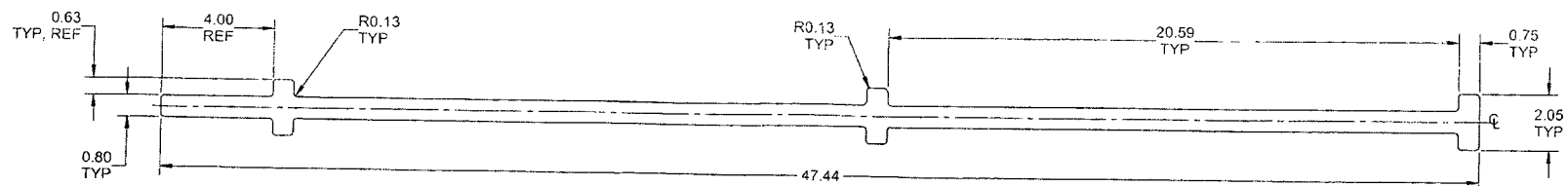
D4672-3 BLANKING PLATE

RELEASED
 2012-07-10
 4 ECLN 12-611

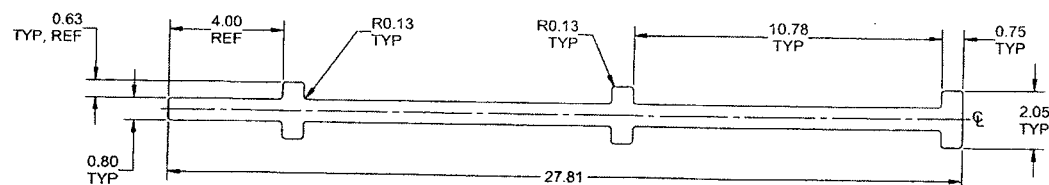
A	NEW ISSUE	MB	12.06.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4672	REV. A SHEET 1 OF 2
TITLE BLANKING PLATE	SCALE NTS
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101186



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4672-X" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4672-1 = 0.47 lbs; D4672-3 = 0.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE OF PART

RELEASED
2012-07-10
ECN 12-64

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4672
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 2
DE APPR.		TITLE BLANKING PLATE
DATE	12.06.13	SCALE NTS
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